

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020404**Date Inspected:** 12-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lui Fawen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed the following work:

Bay 15 – Cross Beam CB17

Flux Core Arc Welding (FCAW) in the 2G position of Side Panel to Bottom Panel weld # CB3001A-017-005. The welders are identified as 500479 and 054459. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-TC-U4b-F.

Bay 14 – OBG 13CW Sub Assy

Flux Core Arc Welding (FCAW) in the 2F position of 13CW sub assy plate SP3112 to 'I' rib weld # SP3112-001-085 & 086. The welder is identified as 044830 and 050242. ZPMC Quality Control (QC) is identified as Guoxing Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-F. See attached photograph Pic_001.

Bay 14 – OBG 13CW Sub Assy

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Sub Arc Welding (SAW) in the 1G position of 13CW sub assy plate BP3069A to BP3070A splice weld # SEG3015A-002. The welder is identified as 045270. ZPMC Quality Control (QC) is identified as Guoxing Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

OBG Segment 9DE

This QA inspector performed Magnetic Particle (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as 9DE X8E to X13E Cutting welds locations as per ZPMC notification # 06383.

The weld designations reviewed are as follows:

SEG056D-040
SEG056E-065, 146 and 173
SSD24PP81.5-168

OBG Segment 9DE

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. The member is identified as 9DE X8E repair welds as per ZPMC notification # 06390.

The weld designations reviewed are as follows:

SEG056E-092 and 101
SEG056D-022 and 031
SSD24PP80.5-168
SSD24PP81.5-168

OBG Segment 9AW-9BW

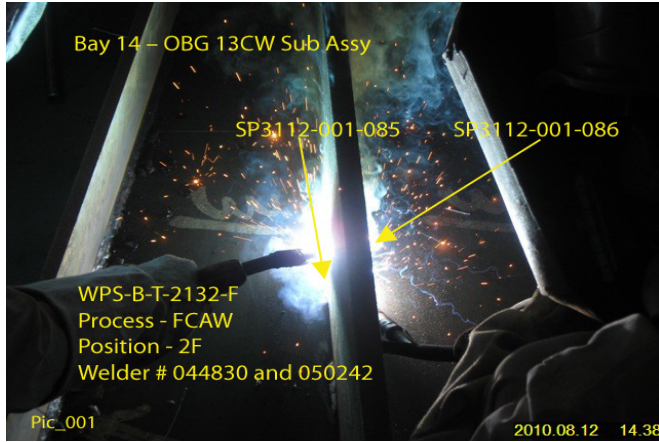
This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. The member is identified as 9AW-9BW 'I' rib splice welds as per ZPMC notification # 06392.

The weld designations reviewed are as follows:

DP671-001-020
EP111-001-014
SP655-001-031

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
